

Date: Monday, 09/03/2009 1:46:45 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BASKET QUICK REALEASE 350/355
Job Number : 46359	
Estimate Number : 10241	
P.O. Number :	Part Number : DSI 9052011
This Issue : 09/03/2009 S.O. No. :	Drawing Number : DSI 9052 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : D
Previous Run : 45838	Material :
Written By :	Due Date : 10/03/2009 Qty: 4 Um: Each
Checked & Approved By : <u>JUD 09.03.09</u>	
Comment : Est Rev:A 02.05.15 New Issue NG	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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for JUD 09/03/13

**Comment:** DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP 9052-011 CHG001

5 09/03/16

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Pick Packing Kit

3.0	BLRS010	Pip Pin
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10 M110638



(4x)

Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 BLRS-010

Quick Release Pin (1" grip)

M109801

M111143 9/3/13

4.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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**Comment:** INSPECT 100% KITS FOR COMPLETENESS

5 09/03/16 (4x)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



(4x)

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D9052-011

Location:

20

Rev A

9/3/13

54

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET QUICK REALEASE 350/355

Job Number: 46359

Part Number: DSI 9052011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

12/09/16

Job Completion



U 9.03.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. DSI 9052	REV. D SHEET 1 OF 1
DATE 04.03.23		TITLE QUICK PIN REPLACEMENT	SCALE NTS
A	96.11.04	NEW ISSUE	
B	96.11.13	ADD PART NUMBERS	
C	03.12.11	ADD DSI 9052-013	
D	04.03.23	ADD CLAMPS ONLY NOTE	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-607 REV. F
(REF. CANADIAN STC: SH94-14, REF. FAA STC: SR00213NY)
AND TO AMEND INSTALLATION DRAWING D350-602 REV. D
(REF. CANADIAN STC: SH93-97, REF. FAA STC: SR01144NY)

PURPOSE: TO ALLOW SUBSTITUTION OF THE BASKET/POD ATTACHMENT BOLTS WITH QUICK RELEASE PINS

THE AN4-12A & AN4-16A BOLTS USED ON D2230-1 CLAMPS MAY BE REPLACED WITH STAINLESS STEEL POSITIVE LOCKING QUICK RELEASE PINS WITH A MINIMUM DOUBLE SHEAR STRENGTH OF 2400 LBS AND 0.25 INCH DIAMETER.

BOLT	MIN GRIP	POSSIBLE QUICK RELEASE PIN REPLACEMENT
AN4-12A	1.0"	AVIBANK: BLC4B10S, BLC4TA10S, BLC4R10S, BLC4LA10S MS NUMBER: MS17984C410, MS17985C410, MS17986C410, MS17987C410 REID: BLRS-010, BLBS-010
AN4-16A	1.3"	AVIBANK: BLC4B13S, BLC4TA13S, BLC4R13S, BLC4LA13S MS NUMBER: MS17984C413, MS17985C413, MS17986C413, MS17987C413 REID: BLRS-020, BLBS-020

THE FOLLOWING OPTIONAL KITS ARE AVAILABLE FROM DART TO PROVIDE QUICK RELEASE CAPABILITY:

QTY -011	QTY -013	PART NUMBER	DESCRIPTION
X		DSI 9052-011	QUICK RELEASE KIT, FOR D350-607-041/-043/-045/-047
	X	DSI 9052-013	QUICK RELEASE KIT, FOR D350-602-011
4	1	BLRS-010	QUICK RELEASE PIN (1" GRIP)
	3	BLRS-020	QUICK RELEASE PIN (1.5" GRIP)

IT IS ACCEPTABLE TO LEAVE THE D2230-1/-3 CLAMPS INSTALLED ON THE CROSSTUBES WHEN THE BASKET OR POD IS REMOVED.

WEIGHT & BALANCE, FOR CLAMPS ONLY, IS 1.8lb (0.82kg) @ STA 135in (3.43m) & BL ±36in (±0.91m).

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 46351

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED	
BY:	<i>[Signature]</i>
D. SHEPHERD (DE # 02)	
DATE:	04.03.23
CERT. NO.:	SH94-14
ISSUE NO.:	4

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED	
BY:	<i>[Signature]</i>
D. SHEPHERD (DE # 02)	
DATE:	04.03.23
CERT. NO.:	SH93-97
ISSUE NO.:	3

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